

Fusor[®] 800DTM/801DTM/803DTM Direct-to-Metal Sealer

Technical Data Sheet

Fusor[®] 800DTM/801DTM/803DTM direct-to-metal sealer is a one-component, moisture-cure product used for duplicating factory appearance on standing seams and cosmetic seams in automotive collision repair and industrial heavy duty truck, bus and trailer repair. Typical applications include: truck bed seams, trailer sidewall and window sealing, tooled door skin seams, floor pan seams, core support seams, brushed seams and other applications in which a non-sag cosmetic seam sealer is required.

Fusor sealer is available in the following colors:

- Neutral – Fusor 800DTM Sealer
- White – Fusor 801DTM Sealer
- Black – Fusor 803DTM Sealer

Features and Benefits:

Durable – creates high strength bonds with or without primer; exhibits excellent primerless adhesive properties.

Convenient – single component requires no mixing; skins over quickly at room temperature, reducing cycle time.

Non-Sag – remains in position when applied on vertical or overhead surfaces, allowing for greater process flexibility.

Easy to Use – easily dispensed; can be tooled and/or painted immediately.

Excellent Appearance – duplicates all types of OEM seals; holds brush marks without die back; weld-through with no burn back.

Chemically Resistant – solvent resistant when cured. Painting and most cleaning processes do not affect bond strength.

Temperature Resistant – uncured material can endure 225°F (107°C) for 60 minutes, and cured material can endure 325°F (163°C) for 60 minutes with no negative effect.

Environmentally Resistant – resists weathering and aging; provides excellent resistance to indirect UV exposure.

Application:

Prepare – Clean the area to be sealed with Fusor 703 adhesion prep/cleaner. Surfaces should be free of grease, dirt and other contaminants.

Apply – Using Fusor 313 manual seam sealer gun, apply sealer to substrate and mate the parts within the work time of the material. Do not allow the material to skin over before mating parts.

If desired, tool or acid brush the sealer to the desired texture. If tooling, use the reducer from your paint system. Avoid using other solvents or water as this may inhibit the curing characteristics or performance of the product.

Note: Various applications, cleaners/solvents and coatings may not be compatible with this product and should be tested by the user before proceeding with intended repair procedure.

Typical Properties*

| | |
|----------------|---|
| Appearance | Neutral, White or Black Paste |
| Base Chemistry | Silane Terminated Polymer (STP) |
| Skin Time** | 25 minutes @ 70°F (21°C), 50% RH |
| Paint Time | Immediately; up to 30 days without a scuff |
| Cure Time | 72 hours @ 70°F (21°C) |

*Data is typical and not to be used for specification purposes.

**Varies with temperature/humidity.



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Finish – Cure will vary depending on temperature and humidity. Product cures 1/8 inch every 24 hours at 77°F (25°C). Product thickness will determine full cure time.

Prime and paint per manufacturer's recommendations immediately or within 30 days on dirt- and dust-free surface..

For more application information, refer to www.lord.com/fusor for standard operating procedures or application training videos.

Shelf Life/Storage

Shelf life is 15 months when stored in a well ventilated area at or below 80°F (27°C) in original, unopened container. Once cartridge has been opened, leave the dispense tip on to act as a seal against moisture.

Cautionary Information:

Before using this or any Parker LORD product, refer to the Safety Data Sheet (SDS) and label for safe use and handling instructions.

For industrial/commercial use only. Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.

| Durability Performance* | |
|--------------------------------------|---|
| Hardness Shore A | 50 |
| Tensile Strength | 200 psi (1.38 MPa) minimum |
| Lap Shear Strength | 200-500 psi (1.38-3.45 MPa) |
| Elongation ASTM D412 | 400% minimum |
| Bond Strength† | |
| Hot Dipped Galvanize (HDG) | |
| 0.047" | 439 psi (3.03 MPa); cohesive failure (95%) |
| 0.047" & 80-grit Grind | 400 psi (2.76 MPa); cohesive failure (98%) |
| Galvaneal | |
| 0.029" | 411 psi (2.83 MPa); cohesive failure (97%) |
| 0.029" & 80-grit Grind | 311 psi (2.14 MPa); adhesive failure (53%) |
| Cold Rolled Steel (CRS) | |
| 0.030" | 285 psi (1.96 MPa); adhesive failure (97%) |
| 0.030" & 80-grit Grind | 434 psi (3.00 MPa); cohesive failure (98%) |
| Aluminum (AL) | |
| 0.034" 6022T6 | 157 psi (1.09 MPa); adhesive failure 99% |
| 0.034" 6022T6 & 80-grit Grind | 393 psi (2.71 MPa); cohesive failure (90%) |
| Cromax 2580CR Scuffed on 0.030" CRS | 498 psi (3.44 MPa); cohesive failure (100%) |
| Valspar VP50 Scuffed on 0.030" CRS | 418 psi (2.88 MPa); cohesive failure (100%) |
| Polyester Paint on 19 Ga 3003 H16 AL | 483 psi (3.33 MPa); cohesive failure (100%) |

*Data is typical and not to be used for specification purposes.

† Bond strength data was obtained using Fusor 800DTM/803DTM sealer with 0.010" glass beads. Please contact Parker LORD regarding the use and/or performance of using other combinations (+1 877 ASK LORD).

Fusor® Repair Products Lifetime Guarantee*

LORD Assembly & Protection Solutions Division of Parker-Hannifin Corporation ("Parker LORD") guarantees to the user that Fusor® Repair Products (adhesives, primers, seam sealers and foams only), when used in strict accordance with Parker LORD application and use instructions, will provide a durable repair for the life of the vehicle per the product's technical data sheet. The user is solely responsible for determining the Fusor product and application method for the repair. Application and product guidance can be found on Fusor.com.

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Parker LORD shall not be liable under any circumstance for any liability, loss, damage or expense directly or indirectly arising from the application and use of Fusor Products sold hereunder or from any other cause. Parker LORD shall not be liable under any circumstances for consequential, indirect or special damages. **PARKER LORD'S LIABILITY FOR BREACH OF WARRANTY HEREUNDER IS IN ALL INSTANCES LIMITED SOLELY AND EXCLUSIVELY TO THE REASONABLE COSTS OF REPAIR AND/OR REPLACEMENT OF THE BONDED COMPONENTS OF THE VEHICLE.**

This guarantee shall only apply to the above referenced Fusor products sold by Parker LORD on or after January 1, 2001.

Fusor Metal Bonding Adhesives shall only be used for the adhesive-only bonding (no welds or rivets) of metal to metal assemblies (steel or aluminum) in full or partial panel replacements of door skins, roof skins, quarter panels, rear body panels and other outer body sheet metal where approved by the vehicle manufacturer.

Fusor products shall not be used for adhesive-only bonding of any structural component unless specifically recommended by the vehicle manufacturer. Structural panels must be replaced in strict compliance with vehicle manufacturer guidelines. If in doubt as to what is a structural component or the proper installation method, contact the vehicle manufacturer. Further, any Fusor products used in marine composite repair, such as with personal water craft and the like, shall be limited to repairs above the water line.

If you have any questions or need to receive proper use instructions, contact the Parker LORD Customer Support Center at +1 800 234 Fusor (3876) or visit Fusor.com.

To comply with the requirements of the Fusor Repair Products Lifetime Guarantee, attach a copy of this completed page to the repair record, and retain with your files:

Vehicle Make/Model: _____

Vehicle Identification Number: _____

Fusor Product(s) Used for Repair: _____

Lot Number(s) on Cartridge(s) Used for Repair: _____

**This guarantee is void if product is used after the date printed on the cartridge label. Parker LORD Terms and Conditions of Sale shall apply to all sales of Fusor products.*



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Instructions contained in this document need to be followed to qualify for the LORD Fusor Lifetime Guarantee. Values stated in this technical data sheet represent typical values as not all tests are run on each lot of material produced. For formalized product specifications for specific product end uses, contact the Customer Support Center.

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